










Date: Friday, 21/11/2008 1:29:21 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Job Number : 43691 Estimate Number : 10720 P.O. Number : This Issue : 21/11/2008 S.O. No. : Prsht Rev. : NC First Issue : / / Type : LARGE FAB ASSY Previous Run : 43555 Written By : Checked & Approved By : Comment : : Est Rev:B 05/10/14 Modified step 10 KJ/EC : Est Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM : Est Rev:C 06-06-27 Revised as per DSI9340 JLM	Drawing Name : SHORT STEP ASSEMBLY HIGH SKID RH Part Number : D350591214UP Drawing Number : D3078 REV A Project Number : N/A Drawing Revision : A Material : Due Date : 05/01/2009 Qty: 1 Um: Each	
Additional Product		
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
 HJ for JLD 08.11.27 		
Comment: DOCUMENT CONTROL Photocopy bluefile and type labels as per PPP D350-591-214 CHG002		
2.0	D2622120C	Step Extrusion
 		
Comment: Qty.: 0.5000 Each(s)/Unit Total : 0.5000 Each(s) Pick: Qty Part Number Description Batch .5 D2622-120 Extrusion B36923		
SAD 08-11-24		
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
 		
Comment: LARGE FABRICATION RESOURCE 1 1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078 2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets. 3-Deburr		
SAD 08-11-24		
4.0	QC5	INSPECT WORK TO CURRENT STEP
 		
Comment: INSPECT WORK TO CURRENT STEP		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY HIGH SKID RH

Job Number: 43691

Part Number: D350591214UP

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3067-1

End Plate B41032

(IX)

SP 08.11.24

6.0

D30631

Support



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3063-1

Support B41031

(IX)

SP 08.11.24

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3078

A/R Aluminum Rod

M109213
H104855

SP 08.11.24 (X)

3-Grind End Plate flush

SAD 08-11-25 (IX)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Pl 08.11.25 RE 08-11-25 (X)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sosulor KRH

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-4 08/11/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: SHORT STEP ASSEMBLY HIGH SKID RH

Job Number: 43691

Part Number: D350591214UP

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F2 08/11/26 (P)

12.0

D3065041

Step Leg Assembly Hi



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3065-041 Step Leg Assy B41445

SAD 08/11/26 (P)

13.0

D30661

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3066-1 Spacer B42345

SAD 08/11/26 (P)

14.0

MS20600AD4W4

Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 MS20600AD4W4 Rivet M109545

SAD 08/11/26 (P)

15.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Rivet Leg Assembly as per Dwg D3078.

SAD 08/11/26 (P)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.11.27 (P) R4

17.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3067-1 End Plate B21032

SAD 08.11.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP ASSEMBLY HIGH SKID RH

Job Number: 43691

Part Number: D350591214UP

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3078

A/R Aluminum Rod M 104855

SP 08.11.27 (1X)

4-Grind End Plate flush

SP 08-11-27 (2)

19.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Cpl 08-11-27 ERF 08-11-27 (1X)

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Soul 07 ALRN

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch Up Chemical conversion

DO NOT PAINT

DO NOT APPLY WING WALK

M. L

08/11/27

(1X RH)

22.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

08-11-27

(21 RH)

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 43691

Part Number: D350591214UP

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

D22303

Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2230-3 Clamp

42316

25.0

D22301

Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2230-1 Clamp

41819

26.0

D2732

Rubber Extrusion



Comment: Qty.: 1.0000 f(s)/Unit Total : 1.0000 f(s)

Rubber Extrusion

4 X 3"

Batch:

38509

27.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 0.6000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2856-400(7.2") Abrasion Strip

42076

28.0

AN335A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A Bolt

4108827

29.0

AN411A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 AN4-11A Bolt

4106605

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: SHORT STEP ASSEMBLY HIGH SKID RH

Job Number: 43691

Part Number: D350591214UP

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

AN413A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch:

109285

SS 08/11/27 (X)

31.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10

Washer

M109061

SS 08/11/27 (X)

32.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN960JD416

Washer

M08827

SS 08/11/27 (X)

33.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3

Nut (or -3)

M109031

SS 08/11/27 (X)

34.0

MS21042L4

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS21042L4

Nut (or -4)

M108145

SS 08/11/27 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 43691

Part Number: D350591214UP

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8 Oct 11/22 / 7/12/10

36.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-214

Location: _____

PPP Rev: _____

Rev D

SS 08/11/28 (X1)

Label checked SS

37.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/01

Job Completion



MF 08-11-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3078	REV. A SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, HI SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

RELEASED
02.01.20 *[Signature]*

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

wlo
43691

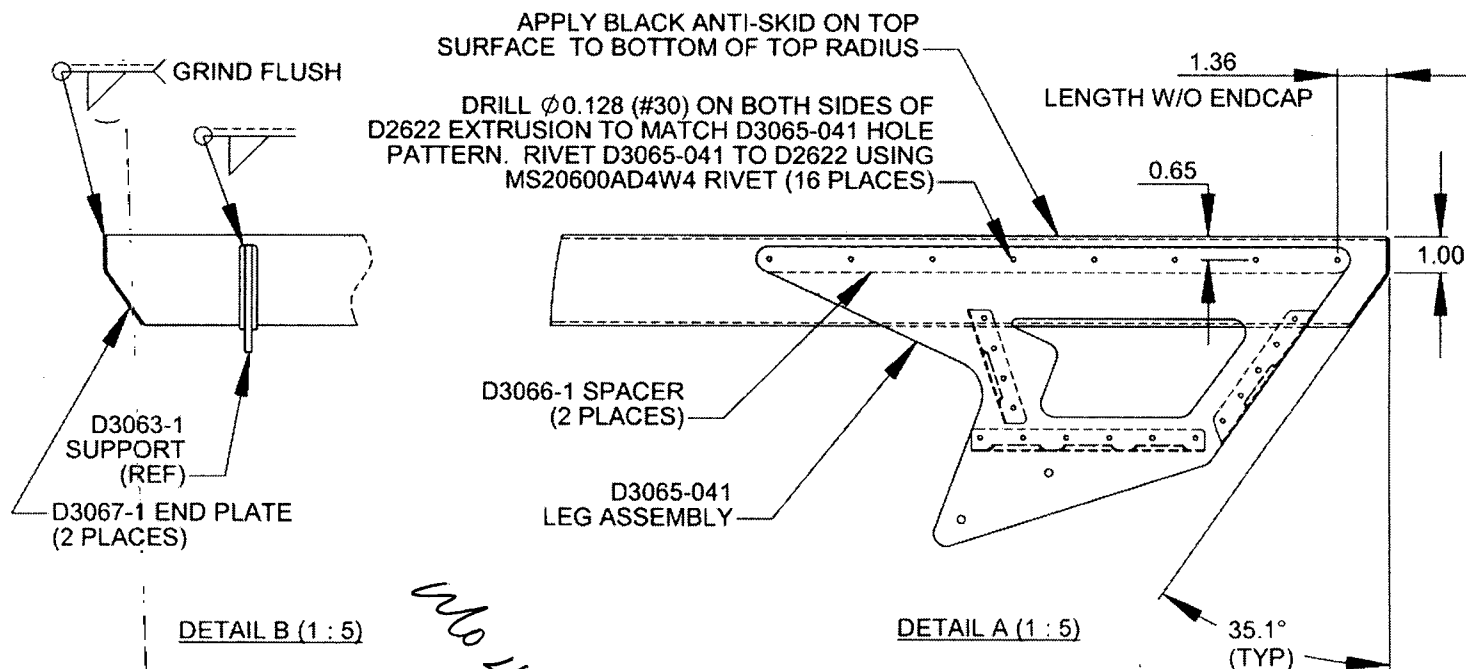
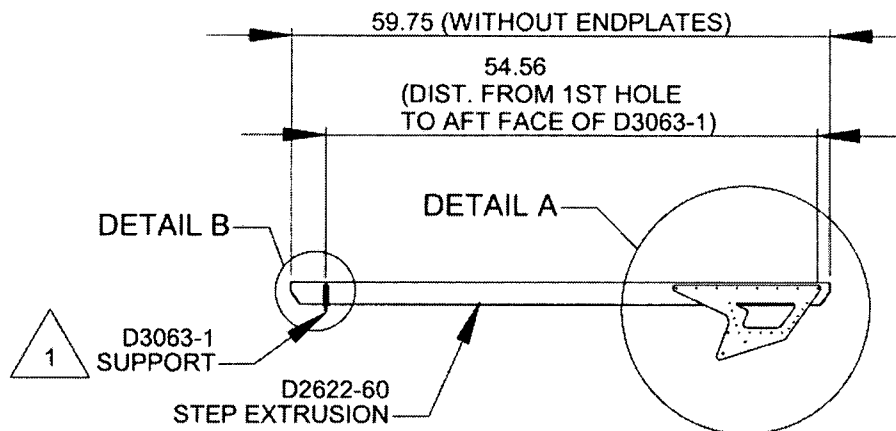
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DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE		REV. A
02.09.11		SHEET 2 OF 2
TITLE	DRAWING NO.	
STEP ASSEMBLY, HI SHORT	D3078	
SCALE		
1:20		

DELIVERED
02.07.2011



Wb 43691

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